'Work Ord Thursday, Dece			A						- 13/64 -			Page
Item ID: Revision ID:	D4108-7		(Do	Accept					Setup	Start		
Item Name:	Bracket		`		÷		Ĵ.			Stop		
Start Date: Required Date: Reference:	12/16/2010 : 12/21/2010	Start Qty: 6.00 Req'd Qty: 6.00	1887 184 188 1881 184 186		Cust Item I Customer:	D:					,	
Approvals:	Process Pla	nn:		Tooling: SPC (Y/N):		ate:]	Run	Start Stop		
Sequence ID/ Work Center I	D	Operation Description	·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr				-						
D4108	A											
Bandsaw Jeaspa Bandsaw		Cut blanks as per folio Memo		0.00 0.00 And	iolizlao				E	<u></u>		
HAAS 1	I machine #1		PER DWG AND FOLIO FA9 EV:_ <i>人人</i> v: - 久	0.00 0.00	, 10/12/20			Le	<i>-</i>			•

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W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				·						
Part No	:	PAR #:	Fault Categ	NCR: Yes No DQA: Date:						
	Resolution:		Disposition	:	_ QA: N/C Cld	sed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NCR)				
DATE	STEP	Description of NC		ver			erification Approval			
DAIL	JICF	Section A	Initial Chief Eng	Action Description Chief Eng	ription Sign & Date		on C	Chief Eng	QC Inspector	
<u></u>										
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l										

Work Order ID 64767

Thursday, December 16, 2010 11:46:13 AM



Page 2

Item ID:

D4108-7

Accept

Setup Start



Revisian ID:

Item Name:

Bracket

Start Date: 12/16/2010 **Required Date: 12/21/2010**

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop

Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/ **Run Hours**

0.00 and10/12/20

Tool ID

Tool # Plan Code Accept Qty

Reject Qty

Reject Insp. Number Stamp

QC8- Inspect parts - second check

0.00

D.A 10/12/20

130

Quality Control

Memo

140

Packaging

Packaging

Identify as per dwg & Stock Location: 129

0.00

Memo

0.00

W/O:			WC	ORK ORDER CHANG	ES			
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA: _	Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C Cld	osed:	Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMA	NCE (NCR)		
DATE	CTED	Description of NC		Corrective Action Section		Verification	on Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector

Work Order ID 64767

Thursday, December 16, 2010 11:46:13 AM



Page 3

Item ID:

D4108-7

Accept

Setup Start

Stop



Revision ID:

Item Name: Bracket

Required Date: 12/21/2010

12/16/2010

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

QC:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date: Run Start

Stop



Sequence ID/

Work Center ID

150

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code Reject Qty

Accept

Qty

Reject

Insp. Number Stamp

Memo

0.00

Quality Control

W/O:	•		\ <i>N</i> / <i>C</i>	ORK ORDER CHANG	SEC				
DATE	STEP	PRO	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector
								Prod Mgr	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No DO	QA:	Date: _	
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Picklist Print

Thursday, December 16, 2010 11:46:17 AM

Work Order ID: 64767

Parent Item:

D4108-7

Parent Item Name: Bracket



Start Date: _2/16/2010

Required Date: 12/21/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 10-10-15 JLM VERIFIED BY:DD

Rev:B 10.12.03 as per dwg rev.B DD verf:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00		Purchased	No		100	f	38.6082	0.2	1.263158	3		

. Banka anaki indinka kia biliki inda inda indin abini bank abin biliki bahk baba indin bank bahin bank bahin

6061-T6 Bar 2.00 x 2.00

Location	Loc Qty	Loc Code	
MAT09	38.6082		
· → 113006	17.0947		1.263 ml 10/2/20
113123	12.5135		
13085	9		

W/O:			wc	RK ORDER CHANG	FS					
DATE	STEP	PRO	OCEDURE CHAI		Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		. //-							Prod Mgr	•
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DART AEROSPACE LTD	Work Order: 64767
Description: BRACKET	Part Number: D4/08-Z
Inspection Dwg: DU/b& Rev: B	Page 1 of 1

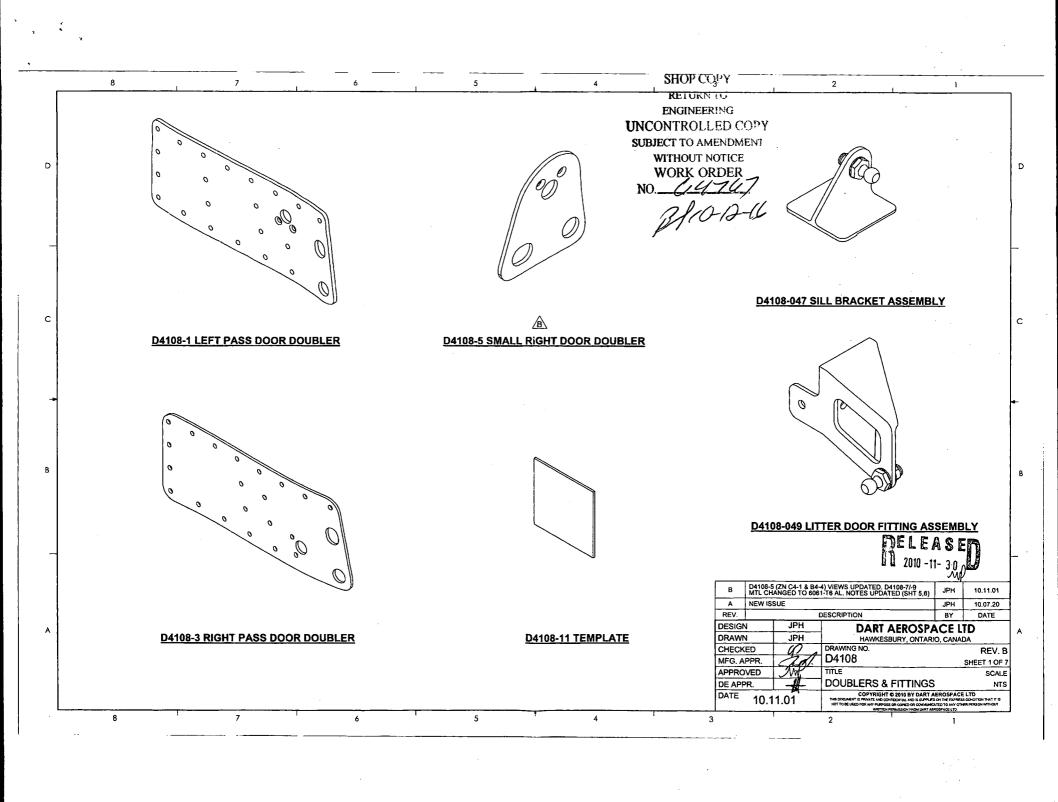
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Date: 10/12/20)	Date:	10/12/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	



W/O:			WO	RK ORDER CHANGI	ES				r	
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3 wlo 44747 0.063 REF 5.60 -CSK 0.225 X 100° 2 PL 0.80 PITCH 0.175 Ø0.128 REF С 23 PL Ø0.375 0.80 2.63 REF -0.254 0.490 2.63 0.71 PITCH 0.60 6.43 REF Ø0.386 0.38 0.25 R0.25 3.50 В TYP 0.87 PITCH **D4108-1 LEFT PASS DOOR DOUBLER** (8) 0.375 0.25 (MAKE FROM D4108-1F) **D4108-1F FLAT PATTERN, LEFT PASSENGER DOOR DOUBLER** NOTES: 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA -1: MAKE FROM D4108-1F. 2) FINISH: NONE.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA JPH DRAWN JPH DRAWING NO. CHECKED REV. B D4108 6) IDENTIFICATION: -1: P/N D4108-1 & B/N PER QSI 044 6.1 MFG. APPR. SHEET 2 OF 7 7) WEIGHT: 0.29 lbs TITLE APPROVED SCALE 8) FORM & INSPECTION PER TEMPLATE DT9648. **DOUBLERS & FITTINGS** DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONTRIDENTAL AND IS SUPPLIED ON THE EXPRESS CONDITION OF THE EXPRESS OF COMMUNICATED TO ANY OTHER PERSONS OR COPIED OR COMMUNICATED TO ANY OTHER PERSONS DATE 10.11.01 8 7 6 5 2

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		Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
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Wo 44147 D 0.063 REF 5.60 Ø0.128 0.80 PITCH 21 PL 0.400 (6) 2.59 0.490 REF 2.63 0.71 PITCH 0.60 0 0 0 0.508 6.39 0.38 0.25 REF Ø0.375 R0.25 3.50 Ø0.386 0.87 PITCH TYP - 0.25 **D4108-3 RIGHT PASS DOOR DOUBLER** (8) 0.375 (MAKE FROM D4108-3F) **D4108-3F FLAT PATTERN, RIGHT PASSENGER DOOR DOUBLER** NOTES: 1) MATERIAL -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA OR M303S16GA -3: MAKE FROM D4108-3F. DESIGN DART AEROSPACE LTD JPH 2) FINISH: NONE DRAWN JPH HAWKESBURY, ONTARIO, CANADA 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED. CHECKED DRAWING NO. 4) UNITS: INCHES UNLESS OTHERWISE NOTED. 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX REV. B D4108 MFG. APPR. SHEET 3 OF 7 6) IDENTIFICATION: -3: P/N D4108-3 & B/N PER QSI 044 6.1 TITLE APPROVED SCALE 7) WEIGHT: 0.29 lbs
8) FORM & INSPECTION PER TEMPLATE DT9649: --**DOUBLERS & FITTINGS** DE APPR.

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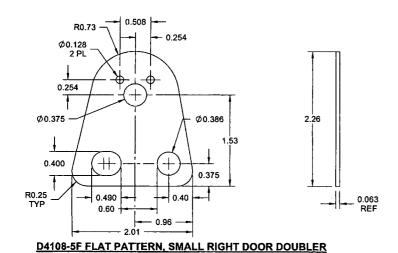
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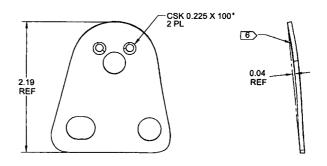
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D4108-5 SMALL RIGHT DOOR DOUBLER (8) (MAKE FROM D4108-5F)

NOTES:
1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
-5: MAKE FROM D4108-5F.
2) FINISH: NONE.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) UNITS: INCHES UNLESS OTHERWISE NOTED.
5) BREAK SHARP EDGES: 0 005 TO 0.010 MAX
6) IDENTIFICATION: -5: P/N D4108-5 & B/N PER QSI 044 6.1
7) WEIGHT: 0.06 lbs

7) WEIGHT: 0.06 lbs

8) FORM & INSPECT PER TEMPLATE DT9649.

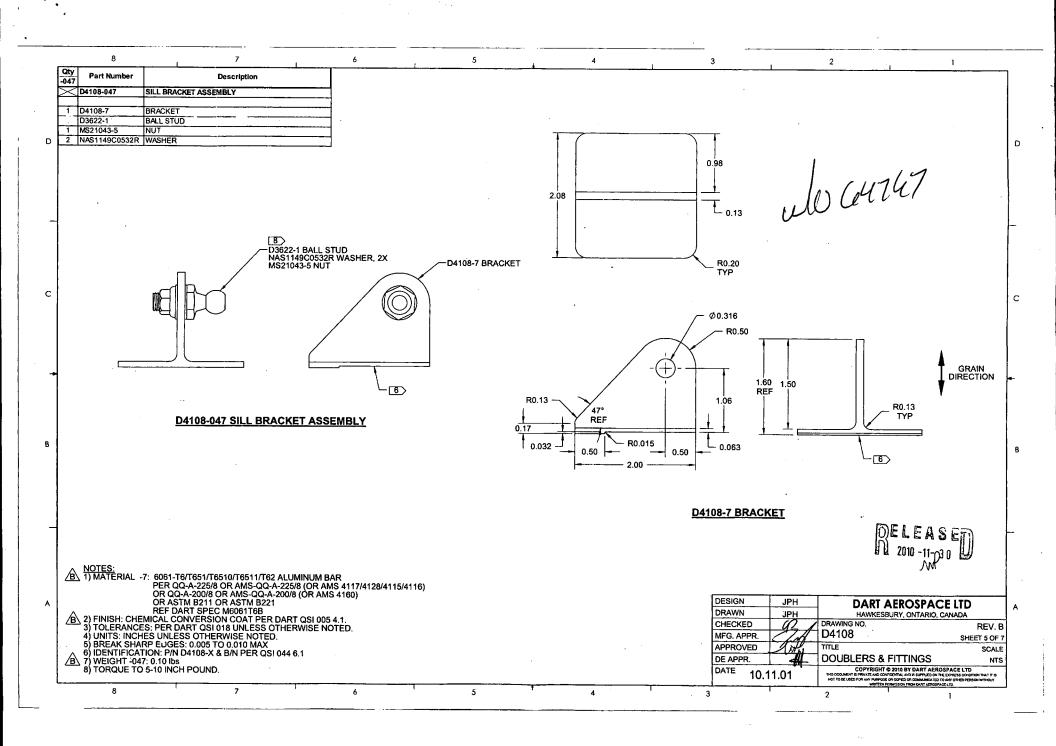
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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA					
CHECKED	Q. 1	DRAWING NO.	REV. B				
MFG. APPR.	[//	D4108	SHEET 4 OF 7				
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DATE 10.	11.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE COCAMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONCITION THAT IT IS NOT TO SE USED FOR ANY PURPOSE OR COPIED ON COMMANDATED TO ANY OTHER PERSON WITHOUT WITH					

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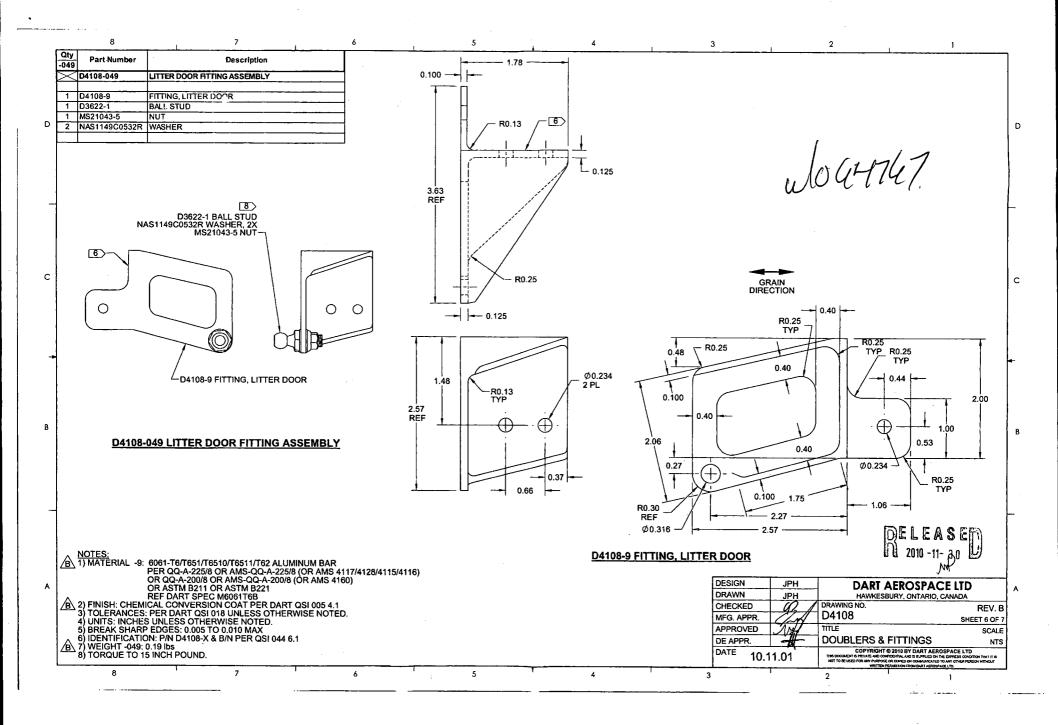
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2.00 0.060 REF - 2.08

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D4108-11 TEMPLATE

NOTES:
1) MATERIAL: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NCTED
4) UNITS: (NCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PIN D4108-11 PER QSI 044 6.1
7) WEIGHT: N/A

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DESIGN	JPH	DART AEROSPACE	LTD						
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA							
CHECKED	01	DRAWING NO.	REV. B						
MFG. APPR.	126	D4108	SHEET 7 OF 7						
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DATE 10.	11.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONTENENT, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OF COMMANDATED TO ANY OTHER PETSON WITHOUT WAYTED PREPARATION FOR USER A PROPERTY OF IT. WAYTED PROPE							

Dart Aerospace

W/O:		WORK ORDER CHANGES										
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